

Work Order ID 81285

March-12-12 3:54:46 PM

81285

Page 1

Item ID: D206-642-641

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 12/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/12 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3288

Rev G

0.00

0.00

100

100

DC

Document Control

Memo

Photocopy bluefile and create labels per PPP D206-642-641
CHG003

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81285***81285***

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr FWD edge of tube,grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288,Grind to obtain proper fit

A/R AL ROD Batch: M120164

4-Grind welds flush to cap on top surface only.

5-Cut Aft end as per Dwg D3288 from front of tube then deburr ✓

6-Remove inner indexing ridge on aft end as per Dwg d3288 ✓

7-Open holes for aft cap as per Dwg D3288 using Dt8025 ✓

8-Drill pilot holes using DT8818 ✓

9- open float holes section J-J (6 per side) to 0.297" and aft cap holes to 0.208" ✓

10-Insert D3286-1 doubler using DT8732 & DT8879 ,then locating doubler off the 3/16" holes cleco D3286-1 doubler remove DT8879 ✓

11-Working from center out,drill #30 holes into D3286-1 Doubler.cleco each hole after its drilled,Verify angle of holes to accomodate rivet heads. ✓

12-Install DT8879 to hold doubler. Remove DT8732 then cleco doubler with #30 clecos. Remove DT8879 open GHW to 0.500" ✓

SAD 12-04-02

BE 12-04-02

SAD 12-04-03

W/O:		WORK ORDER CHANGES					
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Page 3

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

13-Remove D3286-1 doubler, identify orientation, deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

SAD 12-04-03

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

SAD 12-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Item Name: Replacement Skidtube

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Required Date: 26/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 QC7-Inspect Chemical Conversion Coat 0.00

140

QC Memo 0.00

Quality Control

1 0 BE 12/04/04

150 0.00

150

Skidtubes Memo 0.00

Skidtubes

1-Open Holes to finished size as per DWg D3288. Debur.

2-Locate, install and rivet doublers using DT8879 as per Dwg D3288. Micro-shave rivets as required.

3-Bond web in place as per Dwg D3288 & QSI 015.
A/RSikaflex-291 M120813

Sikaflex expire date: 12-08-13
Start: 12-4-9 Time: 14:00
Finish: 12-4-9 Time: 14:30
(Adhere for 12 hours)

SAD 12-04-04
CA 12-4-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

March-12-12 3:54:46 PM

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1

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00				1	0	3E	12/04/11
Quality Control									
170		0.00							
170									
CNC Bend 1	Memo	0.00							Pto ->
CNC Delta 100 Bender	Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-641 PAR #: _____ Fault Category: Landing gear skip NCR: Yes No DQA: OK Date: 12/04/27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/4/27

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/17	170	tube dent in wheellocati R.C. machin glitch./malfunc	<u>ASD</u> 12/04/17 PST042	- Ran test Bendr Ran Program sa Remains + Check All BerRe Scrap + Desm tube	SAO 12-04-17	S 12/04/17	<u>ASD</u> 12/04/17 PST042	S 12/04/17

NOTE: Date & initial all entries

81285

March-12-12 3:54:46 PM

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/03/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 26/03/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

180

0.00

180

0.00

Skidtubes

Skidtubes

Memo

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Deburr and remove alodine as required for welding

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

March-12-12 3:54:46 PM

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Start Date: 12/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

0.00

190

Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.
A/RAluminum Rod_____

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required
A/RSS Rod_____

3-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

4-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

200

QC5- Inspect part completeness to step on W/O 0.00

200

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 8

March-12-12 3:54:46 PM

Item ID: D206-642-641

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 12/03/2012 Start Qty: 1.00

1

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Required Date: 26/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
210									
QC	Memo	0.00							
Quality Control									
220		0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing									
230	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
230									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81285

Page 9

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:**Customer:**

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

0.00

0.00

0.00

Memo

0.00

0.00

0.00

Memo

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes
A/RSikaflex-291 _____
Sikaflex expire date: _____

0.00

0.00

0.00

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 10

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Required Date: 26/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00

270

HandFinish

Memo

0.00

Hand Finishing

1-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

2-Install Ring on Nut Plate as per detail F & Dwg D3288.

3-Spray inside tube with LPS-3 on both sides of web

4-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 _____

Sikaflex expire date: _____

5-Coat all exposed fastners with LPS Procyon,remove any excess on powder coat
with MEK Degreasser.

A/R LPS Procyon Batch: _____

280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 11

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290		0.00							
290									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-641 Location: _____ PPP Rev: _____								
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

P12-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 1

March-12-12 3:54:50 PM

Work Order ID: 81285

81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.11.15 Added washers for aft cap, wearshoes and ringEC
 IPP Rev:C 06-05-31 Revised steps JLM
 IPP Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM
 IPP Rev:E 07-12-06 ECN 1080p DD verified by:ec
 IPP Rev:F 08-04-17 as per PAR 08-015 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620		Manufactured	No			110	Each	16.0000	1	1			
D2620									**				
Skidtube, 206 Skidtube													

SAD 12-04-02

Location	Loc Qty	Loc Code
LG	16	
77999	1	
78000	3	
79543	2	
79544	8	
79545	2	

B81365

①

D2647
D2647
 Cap

Manufactured No

110 Each

51.0000 1

B812-04-02

Location	Loc Qty	Loc Code
LG002	51	
75482 ✓	51	

/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3286-1 Manufactured No

110 Each

159.0000 2

D3286-1

Doubler

**

SAD 12-04-03

Location

Loc Qty

Loc Code

LG002

271

74872

6

78014

67

79556

80

ST046

-112

76772

6

CR3212-4-04

Purchased No

150 Each

6,443.000 52

CR3212-4-04

Cherry Rivet

**

52

Location

Loc Qty

Loc Code

ST331

168

116471

78

117816

3

118686

1

118840

16

119017

60

119075

10

st510

6275

119075

6275

D3289-041

Manufactured No

150 Each

0.0000 1

D3289-041

Float Web (206A/B)

**

1

B 82625

1 Cx 12-4-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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March-12-12 3:54:50 PM

Page 3

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81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

1,591.000

9

9

D2649

Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

1134

77574

2

79502

403

79503

399

79504

69

79565

261

LG001

457

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

330

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

March-12-12 3:54:50 PM

Work Order ID: 81285

81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3275-1

Manufactured No

190

Each

307.0000

6

6

D3275-1

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

103

80184

103

LG002

204

66930

106

73393

46

74437

52

D3286-3

Manufactured No

190

Each

97.0000

2

2

D3286-3

Spacer

Location

Loc Qty

Loc Code

LG

3

78015

3

LG001

94

74117

1

79557

93

D3415-041

Manufactured No

250

Each

22.0000

1

1

D3415-041

Nut Plate

Location

Loc Qty

Loc Code

ST042

22

67605

22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-12-12 3:54:50 PM

Page 5

Work Order ID: 81285

Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube

81285

D206-642-641

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

250

Each

693.0000

2

2

CCR264SS3-3

Cherry Rivet

Location

Loc Qty

Loc Code

ST331

693

113973

2

117849

125

119017

566

CR3212-4-03

Purchased

No

250

Each

1,466.000

2

2

CR3212-4-03

Cherry Rivet

Location

Loc Qty

Loc Code

FP002

476

114859

476

ST331

990

110139

2

119017

988

ALS7-1032-130

Purchased

No

250

Each

2,390.000

64

64

ALS7-1032-130

Insert

Location

Loc Qty

Loc Code

ST280

317

117717

27

118966

22

119775

268

ST282

2073

119530

73

120181

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

March-12-12 3:54:50 PM

Page 6

Work Order ID: 81285

81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-15

Manufactured No

270

Each

26.0000

1

1

D3535-15

Wearshoe

Location

Loc Qty

Loc Code

FP001

26

73315

2

74512

12

80328

12

D3535-21

Manufactured No

270

Each

25.0000

1

1

D3535-21

Wearshoe

Location

Loc Qty

Loc Code

FP001

7

70380

1

80329

6

FP002

18

78987

18

D3535-35

Manufactured No

270

Each

35.0000

1

1

D3535-35

Wearshoe

Location

Loc Qty

Loc Code

FP001

35

67598

1

70815

1

78873

13

79849

1

80332

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 7

March-12-12 3:54:50 PM

Work Order ID: 81285

81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-41	Manufactured	No	270	Each	11.0000	1	1
D3535-41						**	
Wearshoe							

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	11	
	42256	11	

D3536-15	Manufactured	No	270	Each	28.0000	1	1
D3536-15						**	
Gasket							

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP002	28	
	73318	16	
	80333	12	

D3536-21	Manufactured	No	270	Each	23.0000	1	1
D3536-21						**	
Gasket							

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP002	23	
	70464	1	
	78966	22	

D3536-35	Manufactured	No	270	Each	36.0000	1	1
D3536-35						**	
Gasket							

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP002	36	
	74511	9	
	80335	27	

March-12-12 3:54:50 PM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 8

Work Order ID: 81285

81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-41
D3536-41
Gasket

Manufactured No 270 Each 13.0000 1 1

Location	Loc Qty	Loc Code
FP002	13	
37353	1	
51646	12	

D3537-1
D3537-1
Wearpad

Manufactured No 270 Each 151.0000 7 7

Location	Loc Qty	Loc Code
FP001	104	
79833	50	
79835	54	
FP002	47	
69817	5	
79834	42	

D3537-3
D3537-3
Wearpad

Manufactured No 270 Each 18.0000 1 1

Location	Loc Qty	Loc Code
FP002	18	
74500	13	
76986	5	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

March-12-12 3:54:50 PM

Page 9

Work Order ID: 81285

81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A	Purchased	No	270	Each	3,645.000	66	66
--------	-----------	----	-----	------	-----------	----	----

AN3C4A

BOLT

Location

Loc Qty

Loc Code

ST350	3645	
117688	5	
118112	16	
119749	10	
120187	2000	
120423	10	
120521	510	
120769	515	
120799	123	
120930	456	

NAS1515H3L	Purchased	No	270	Each	188.0000	2	2
------------	-----------	----	-----	------	----------	---	---

***NAS1515H3I ***

WASHER

Location

Loc Qty

Loc Code

FG	40	
102472	40	
ST277	148	
118686	3	
119438	1	
120072	44	
120360	100	

AN960C10L	NAS1149C0332	Purchased	No	270	Each	0.0000	78	78
-----------	--------------	-----------	----	-----	------	--------	----	----

***AN960C10I ***

washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

March-12-12 3:54:50 PM

Page 10

Work Order ID: 81285

81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3683-1

Manufactured No

270

Each

8,651.000

12

12

D3683-1

Insert

Location

Loc Qty

Loc Code

FP002

8651

36319

8651

D3413-1

Manufactured No

270

Each

79.0000

1

1

D3413-1

Ring

Location

Loc Qty

Loc Code

ST420

21

70773

1

79233

20

ST464

58

76754

34

77940

2

80224

22

AN4C5A

Purchased No

270

Each

269.0000

1

1

AN4C5A

BOLT

Location

Loc Qty

Loc Code

ST355

269

112243

169

119017

100

AN960C416

NAS1149C0463
R

Purchased No

270

Each

0.0000

1

1

AN960C416

washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 11

March-12-12 3:54:50 PM

Work Order ID: 81285

81285

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No

270

Each

138.0000

1

1

D2646

Aft Cap

Location

Loc Qty

Loc Code

FP002

138

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

26

79500

46

79562

50

MS27039C1-05

Purchased

No

270

Each

187.0000

12

12

MS27039C1-05

SCREW

Location

Loc Qty

Loc Code

ST293

187

106574

12

107242

175

March-12-12 3:54:50 PM

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Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
3. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: NONE
7. WEIGHT: 20.8 LBS
8. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
9. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
10. ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN
11. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/291
13. WELDING: PER DART QSI 004
14. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81285 MCT

12/03/12

RELEASED
(9/16/06 AM)

G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17" INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.17		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3288 TITLE SKIDTUBE ASSEMBLY REV. G SHEET 1 OF 4 SCALE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

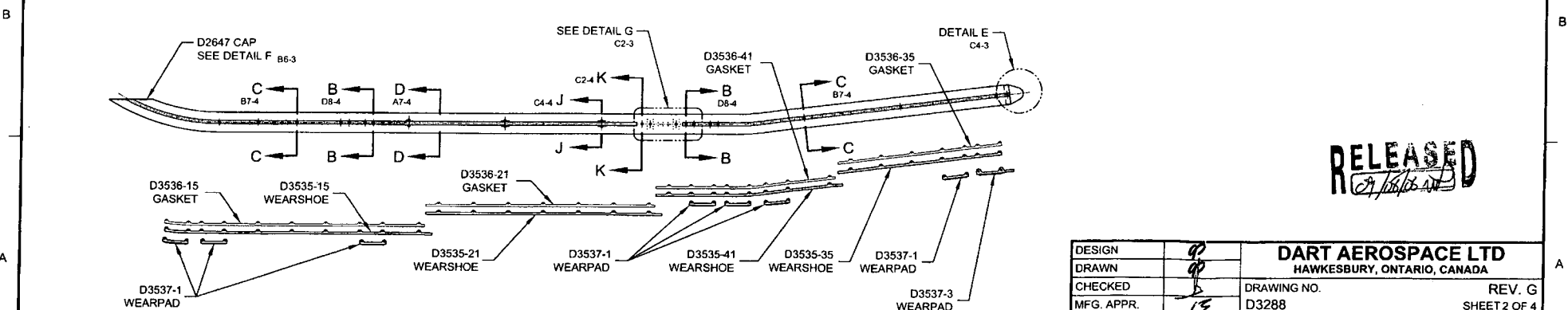
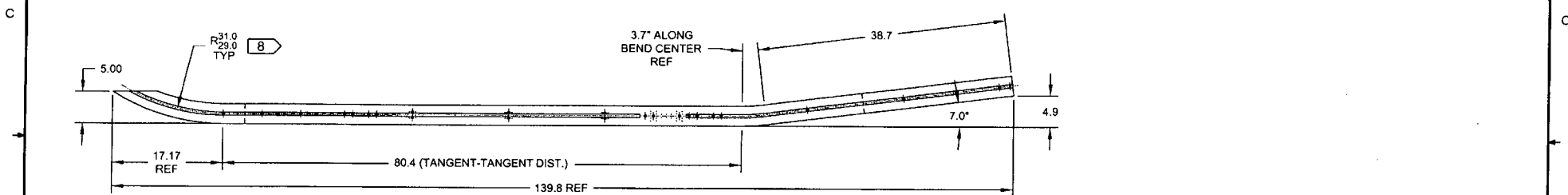
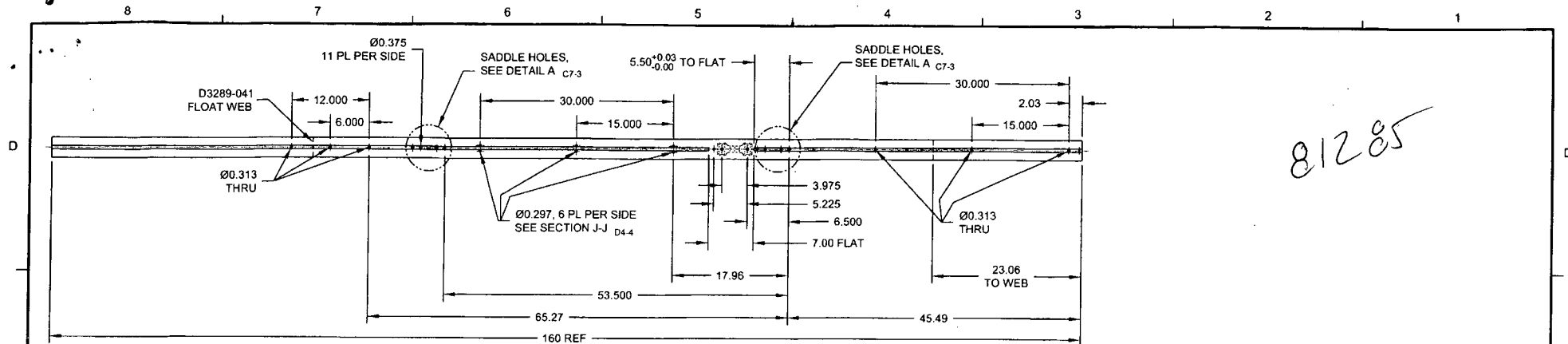
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
21/10/15

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. G
MFG. APPR.	13	D3288	SHEET 2 OF 4
APPROVED	AN	TITLE	SCALE
DE APPR.	AN	SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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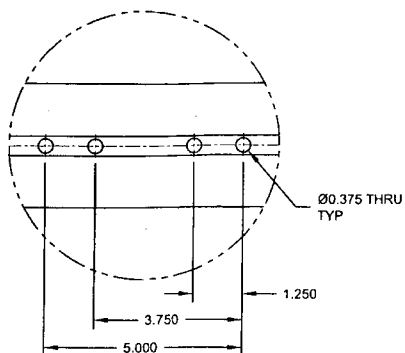
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

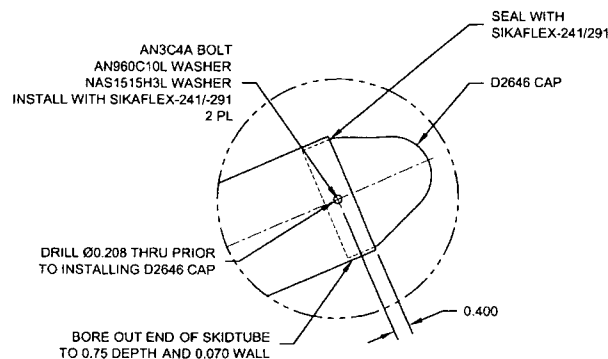
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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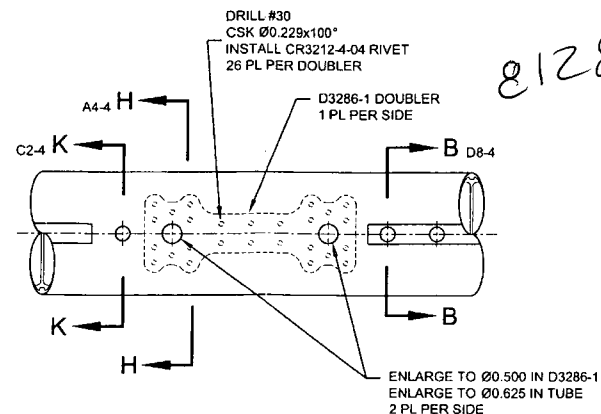
NOTE: Date & initial all entries



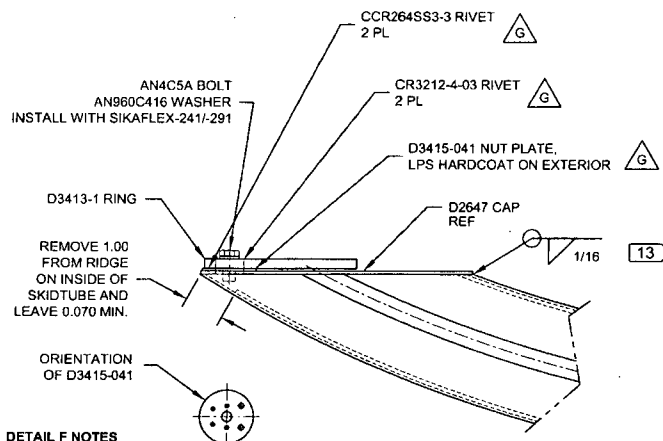
DETAIL A: DRILL DETAIL D6-2, D4-2
SADDLE HOLES, SCALE 5X



DETAIL E B3-2
SCALE 5X



DETAIL G B5-2
SCALE 5X



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL B7-2
SCALE 5X

RELEASED
09/06/17

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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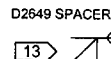
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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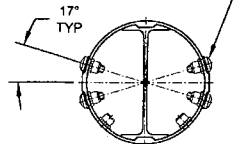
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



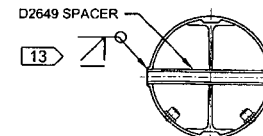
SECTION B-B
B7-2, B5-2, D1-3
FOR Ø0.375 SADDLE HOLES ONLY
8 PL, SCALE 5X

- AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR Ø0.375 SADDLE HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP



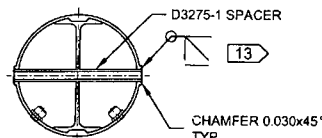
SECTION J-J
D5-2, B6-2
SCALE 5X

- AFTER FINISH, INSTALL D3683-1 INSERT AND PLUG INSERTS USING MS27039C1-05 SCREWS AND AN960C10L WASHERS 12 PL

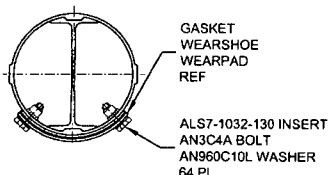


SECTION K-K
B5-2
1 PL, SCALE 5X

- AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THIS HOLE ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH

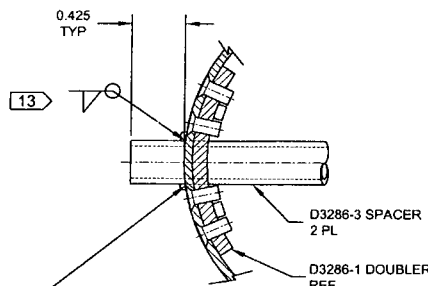


SECTION C-C
B7-2, B4-2
FOR Ø0.313 HOLES ONLY
6 PL, SCALE 5X



SECTION D-D
B6-2
FOR WEARSHOES INSTALL ONLY
32 PL, SCALE 5X

- GASKET WEARSHOE WEARPAD REF
- ALS7-1032-130 INSERT
AN3C4A BOLT
AN960C10L WASHER
64 PL



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION H-H
D3-3
NOT TO SCALE

RELEASED
09/06/17

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries